

Date: Tuesday, 11/29/2005 3:00:22 PM
 User: Linda Lacelle

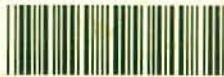
Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 25016 A	Part Number	: D2571
Estimate Number	: 10530	Drawing Number	: D2571 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 1/5/2006
Previous Run	: 24837	Qty:	14 Um: Each
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: SEE ABOVE DATE & USER		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: 825205 (1)

B24070 (13)

J.G. 06/01/29

14

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 25016 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges

J.G. 06/01/29

14

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

J.G. 06/01/29

14

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G. 06/01/29

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 16/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 3:00:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25016

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06.02.23 14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-03-01

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-03-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MA 06 03 06 14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST478

c 206103107 14

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/08 (14)

Job Completion



U 06.03.07 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

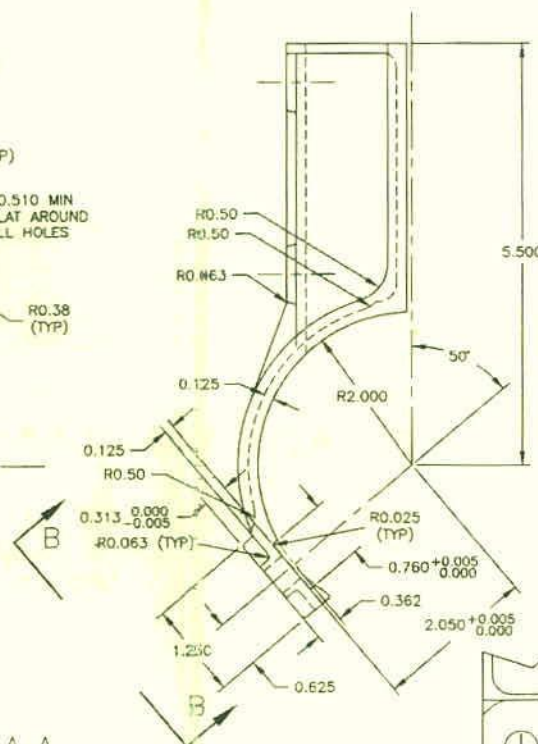
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *SD* Date: 16/02/08

QA: N/C Closed: _____ Date: _____





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			







NOTE: Date & initial all entries

02.09.25



MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |

D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN  DRAWN BY   DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA			
CHECKED 	APPROVED 	DRAWING NO. D2571	REV. _____
DATE 02.09.06		TITLE OUTER FWD SADDLE	SHEET 1 OF _____
			SCALE 2:1

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DART AEROSPACE LTD.

DART AEROSPACE LTD.
WARRICKSBURY, ONTARIO, CANADA

REV
SHEET 1

TITLE	OUTER FWD SADDLE
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REV. 0
T 1 OF 1
SCALE
2:1

1871

1872

1873

1874

1875

1876

1877

1878

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Fwd Outboard		Part Number: D2571	
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

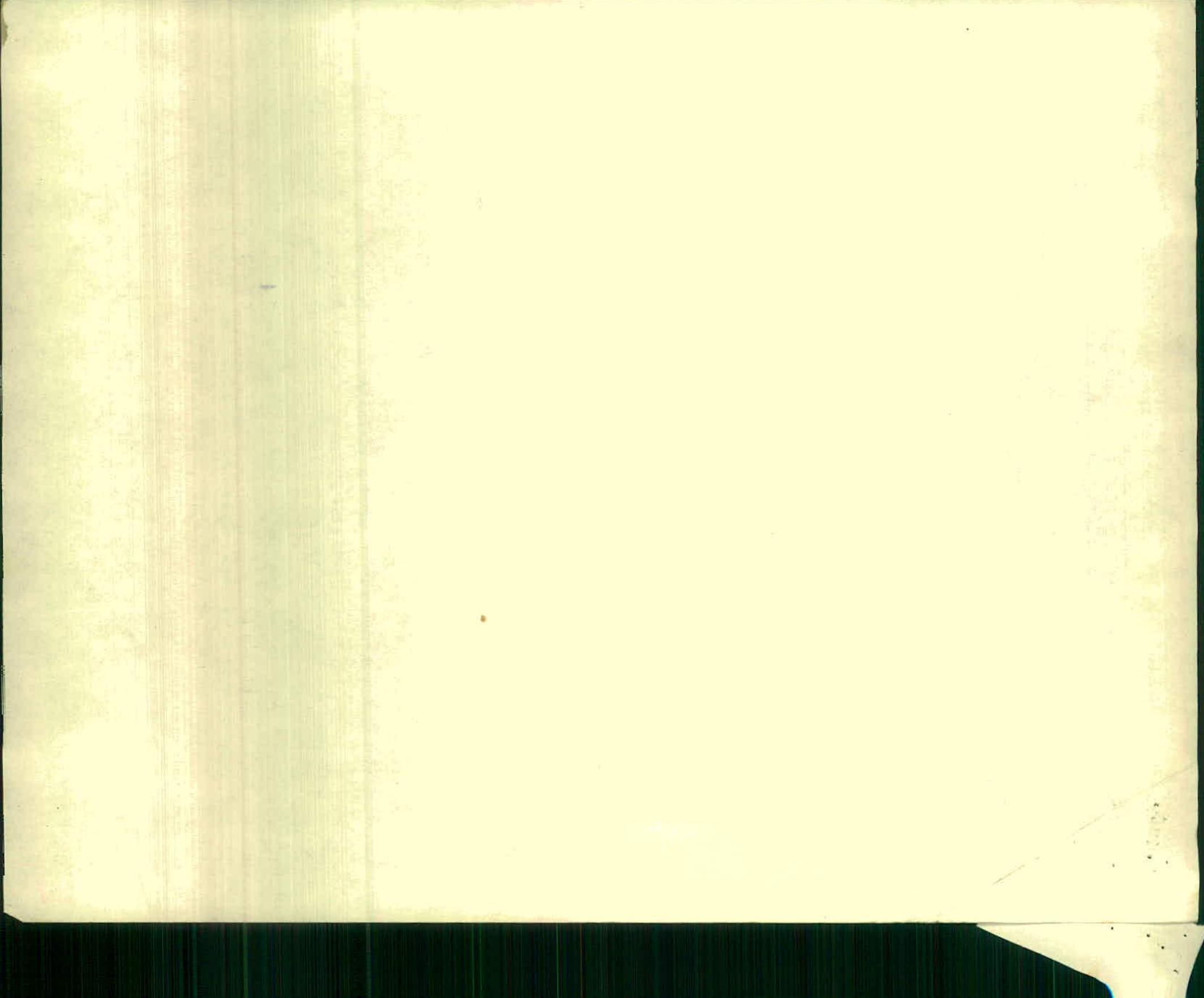
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.747	1.747	1.747		
C	3.495	3.505		3.496	3.497	3.496	3.496		
D	1.745	1.755		1.745	1.747	1.747	1.747		
E	7.990	8.010		8.002	8.004	8.002	8.003		
F	0.490	0.510		0.496	0.496	0.502	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.492	0.502	0.500	0.503		
J	1.174	1.184		1.177	1.178	1.177	1.177		
K	0.558	0.578		0.564	0.565	0.563	0.564		
L	1.174	1.184		1.177	1.178	1.177	1.177		
M	1.490	1.500		1.493	1.494	1.493	1.493		
N	2.495	2.505		2.497	2.497	2.498	2.495		
O	3.869	3.879		3.871	3.872	3.871	3.870		
P	0.115	0.135		0.124	0.125	0.124	0.123		
Q	0.115	0.135		0.132	0.135	0.135	0.135		
R	0.240	0.260		0.248	0.248	0.247	0.248		
S	0.115	0.135		0.131	0.132	0.125	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.959	2.959	2.960	2.960		
V	0.230	0.250		0.244	0.241	0.234	0.234		
W	0.115	0.135		0.131	0.125	0.120	0.126		
X	0.308	0.313		0.310	0.307	0.309	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.372	0.370	0.372	0.372		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.620	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.257	0.250	0.248	0.244		
AE	1.375	1.395		1.384	1.384	1.388	1.391		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.257	0.251	0.245	0.247		
AI	2.000	2.020		2.006	2.000	2.003	2.005		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	Er
Date:	06/02/19

Audited by:	J.L
Date:	06.02.20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED



DART AEROSPACE LTD		Work Order:	
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

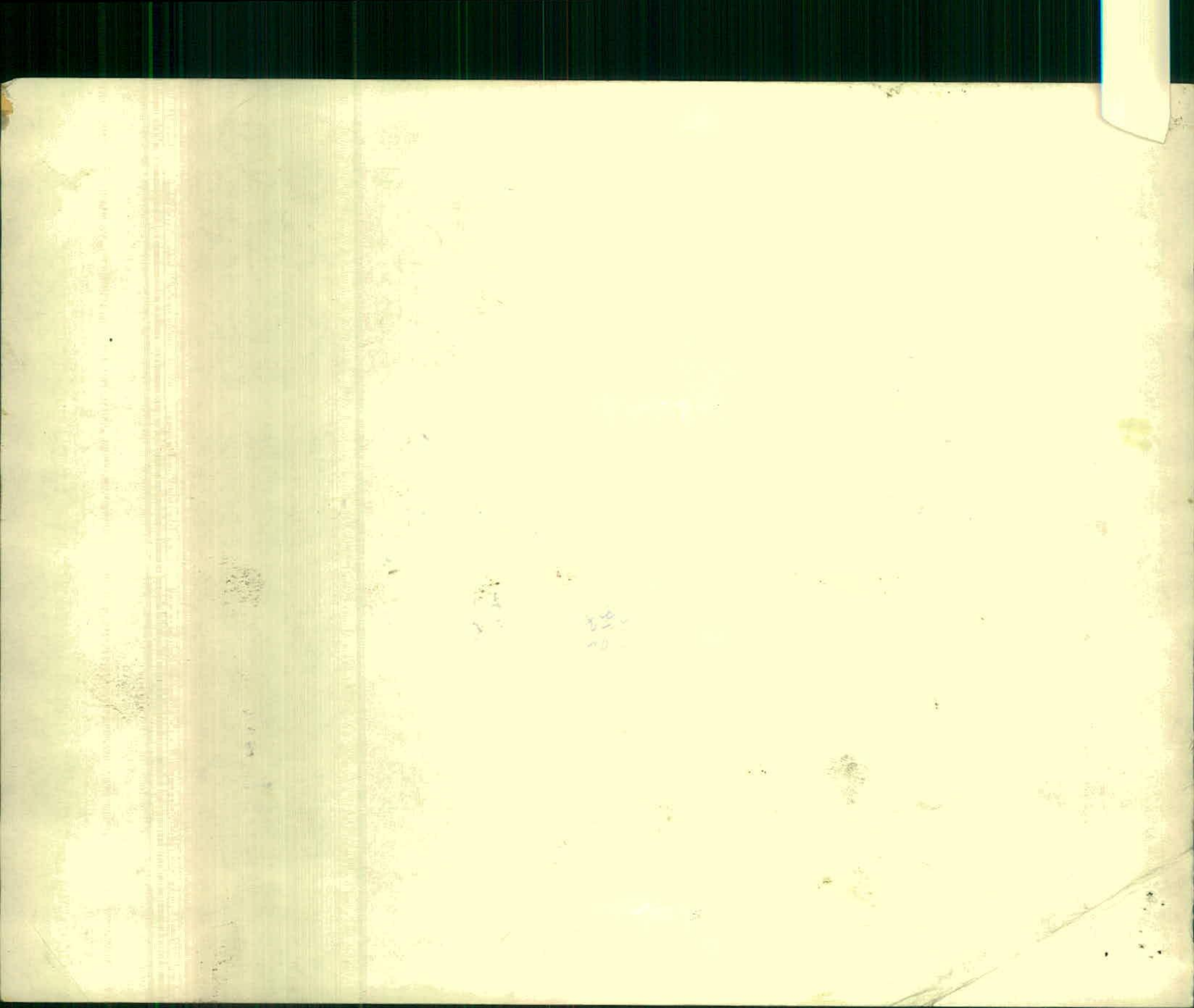
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.747	1.747		
C	3.495	3.505		3.496	3.497	3.496	3.496		
D	1.745	1.755		1.746	1.746	1.747	1.747		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.498	0.500	0.503	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.504	0.502	0.501	0.501		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.565	0.567	0.566	0.564		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.493	1.494	1.494	1.493		
N	2.495	2.505		2.496	2.497	2.499	2.497		
O	3.869	3.879		3.871	3.872	3.872	3.872		
P	0.115	0.135		0.124	0.122	0.122	0.124		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.248	0.246	0.247	0.252		
S	0.115	0.135		0.124	0.122	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.234	0.234	0.233	0.234		
W	0.115	0.135		0.122	0.121	0.125	0.121		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.370	0.370	0.370	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.620	0.623	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.250	0.245	0.244		
AE	1.375	1.395		1.390	1.388	1.380	1.390		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.243	0.245	0.243	0.249		
AI	2.000	2.020		2.004	2.005	2.004	2.005		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	En
Date:	06/02/20

Audited by:	J.L
Date:	06.02.20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
10.2.01



DART AEROSPACE LTD	Work Order: 250164
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.748	1.749	1.749		
C	3.495	3.505		3.499	3.498	3.499	3.498		
D	1.745	1.755		1.747	1.748	1.749	1.749		
E	7.990	8.010		8.001	8.002	8.003	8.003		
F	0.490	0.510		0.501	0.501	0.500	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.501	0.500	0.500		
J	1.174	1.184		1.178	1.177	1.177	1.178		
K	0.558	0.578		0.566	0.567	0.568	0.568		
L	1.174	1.184		1.178	1.178	1.177	1.178		
M	1.490	1.500		1.494	1.494	1.494	1.494		
N	2.495	2.505		2.496	2.497	2.497	2.497		
O	3.869	3.879		3.872	3.873	3.872	3.873		
P	0.115	0.135		0.123	0.125	0.124	0.124		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.248	0.249	0.249	0.249		
S	0.115	0.135		0.122	0.127	0.127	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.233	0.234	0.233	0.233		
W	0.115	0.135		0.121	0.125	0.125	0.125		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.625	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.248	0.247	0.248		
AE	1.375	1.395		1.391	1.390	1.393	1.391		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.247	0.247	0.247		
AI	2.000	2.020		2.006	2.006	2.007	2.008		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	Er/J.G.
Date:	06/02/21

Audited by:	JG.
Date:	06/02/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 25016A
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438				
B	1.745	1.755		1.749	1.748				
C	3.495	3.505		3.497	3.497				
D	1.745	1.755		1.749	1.749				
E	7.990	8.010		8.004	8.003				
F	0.490	0.510	DT8683 DT8684	0.500	0.501				
G	0.257	0.262		0.257	0.257				
H	0.375	0.380		0.375	0.375				
I	0.490	0.510		0.499	0.498				
J	1.174	1.184		1.177	1.177				
K	0.558	0.578		0.568	0.568				
L	1.174	1.184		1.180	1.180				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.499				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		0.125	0.125				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.251	0.250				
S	0.115	0.135		0.127	0.126				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.961	2.963				
V	0.230	0.250		0.240	0.245				
W	0.115	0.135		0.123	0.124				
X	0.308	0.313		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.360	0.361				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.628	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.250	0.250				
AE	1.375	1.395	1.385	1.384					
AF	0.115	0.135	0.120	0.121					
AG	0.240	0.280	0.230	0.230					
AH	0.240	0.260	0.245	0.247					
AI	2.000	2.020	2.008	2.008					
AJ	0.023	0.043	0.030	0.030					
Accept/Reject									

Measured by: J.G.	Audited by: J.G.
Date: 06/02/22	Date: 06/02/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

